



C AXIS TRAM DETAILED CORRECTION INSTRUCTIONS PC

Watch the measurement procedure video! Link: <https://youtu.be/DkNi5vBPnlg>

1. Using a magnetic dial indicator measure the tram (squareness of the axis)

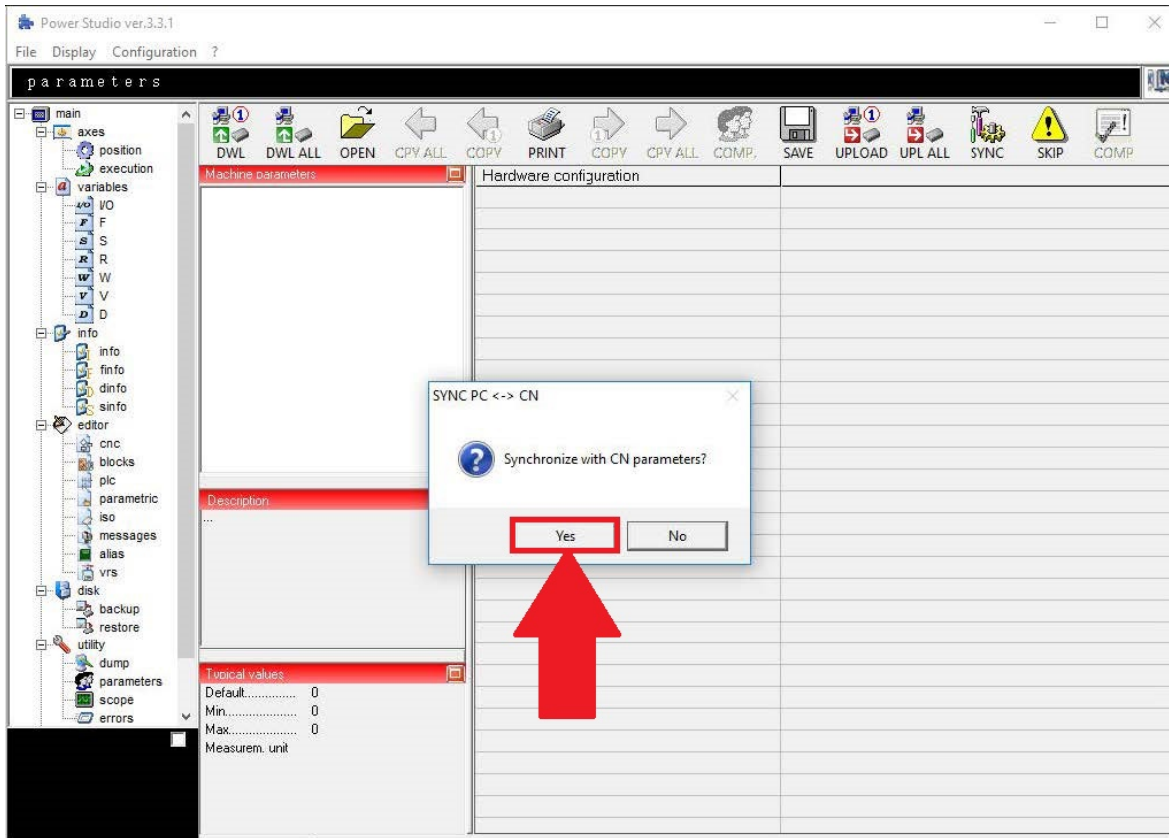
Note: Position the head towards the bottom right corner of the table (as shown in the image). Set dial indicator at 0 on the left side edge of the flange then using a Sharpie, mark the spot where your dial indicator is starting (be sure to only measure on a clean surface area of the flange or blade). Move the head to the left in the X axis until your indicator is touching the right side edge of the flange or blade. Then rotate the flange/blade until your Sharpie mark lines up with your dial indicator. If the tram is not square in the C axis you will have a reading on the indicator (the tolerance of the axis is $\pm .002$). Write this number down. Note whether your error was negative or positive.



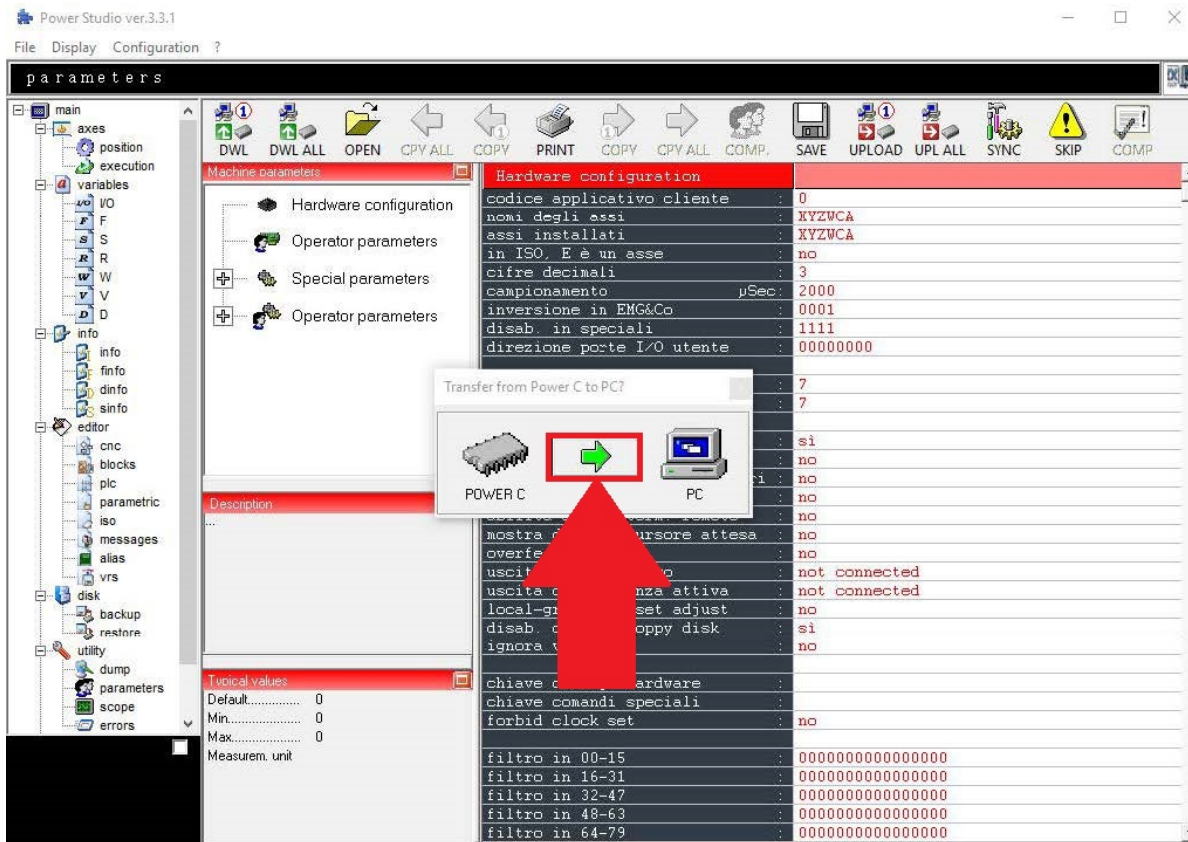
- Click the F19 POWER-STUDIO link (puzzle piece)

- Enter the PASSWORD: 0541
- Click CONNECT in the center of the PowerStudio screen

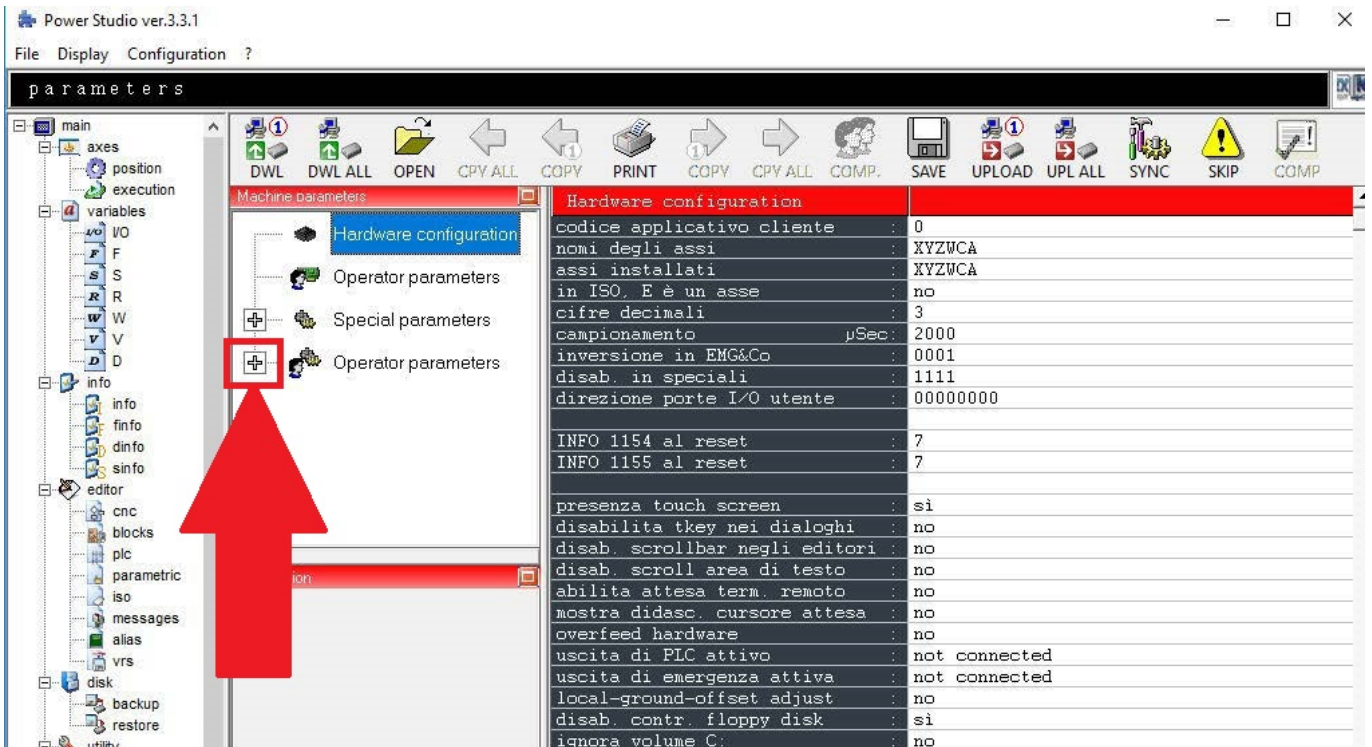
- Click Yes to Synchronize Parameters with PC



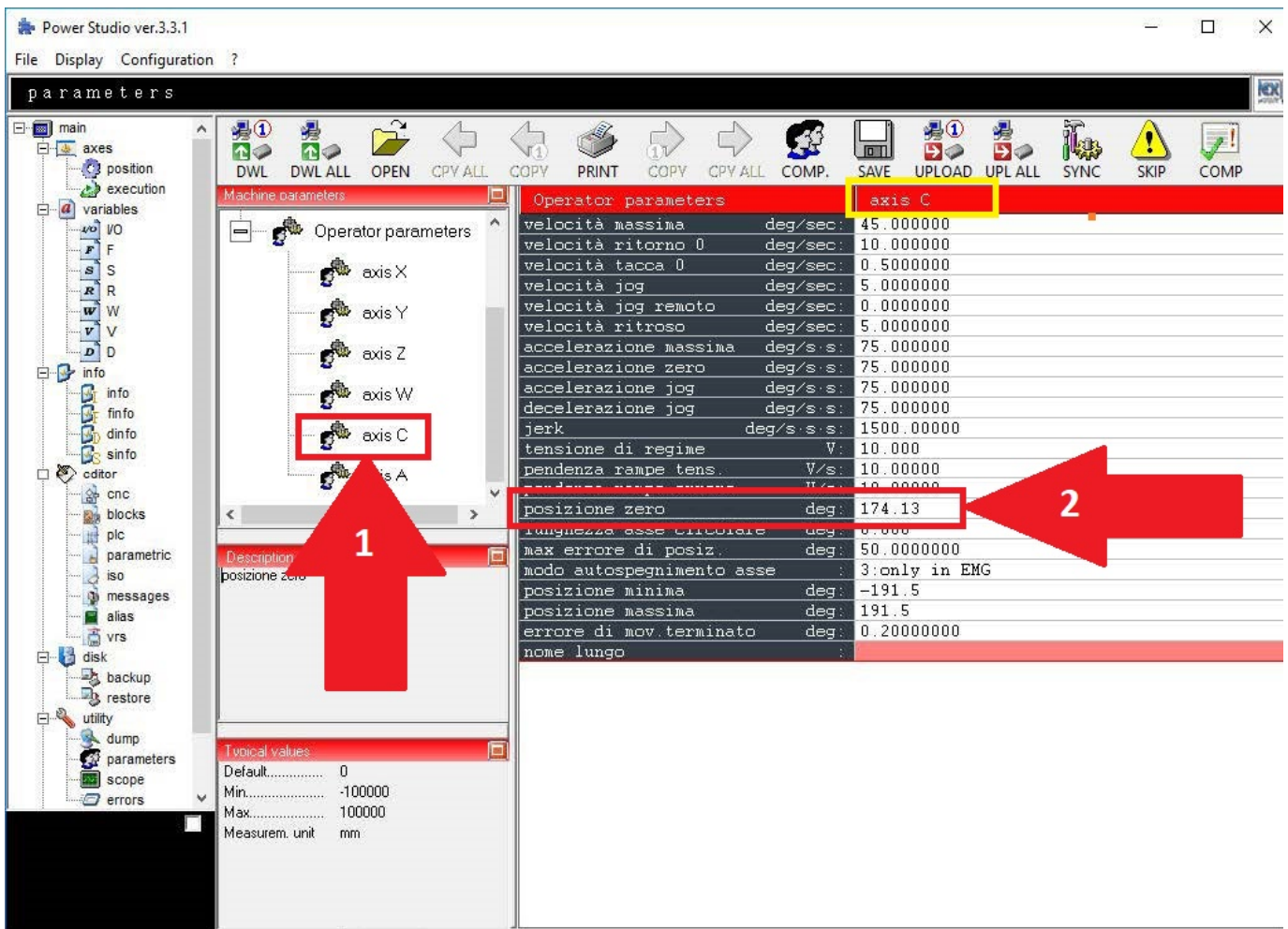
- Click the Green Arrow to Transfer from Power C to PC



- Click OPERATOR PARAMETERS



- Click on C axis (step 1)
- Find "ZERO POSITION" or "Posizione Zero" (step 2)



Note: If the error from STEP 1 is positive then the value must reduce.

o Example:

➤ Original Zero position=174.13

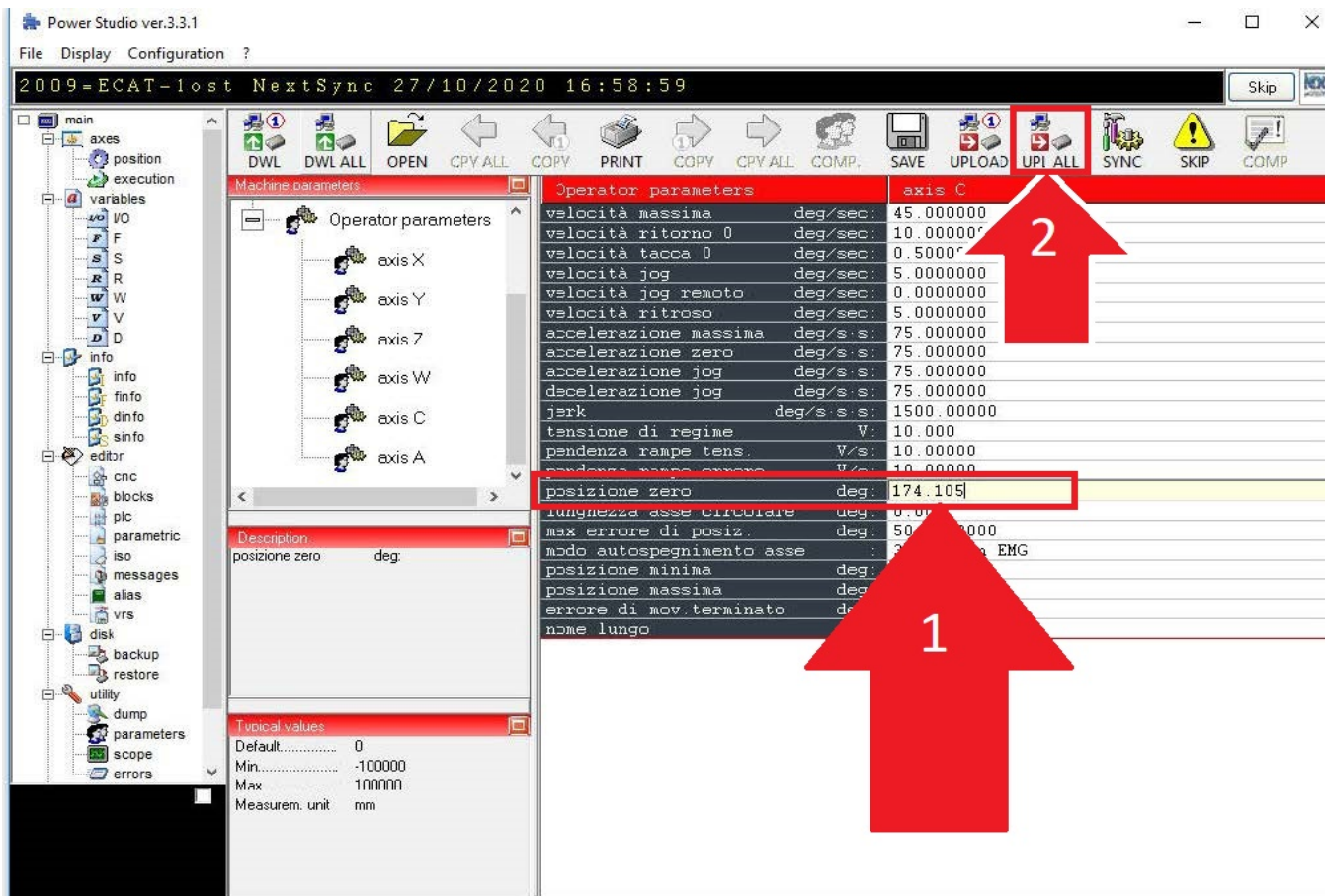
Error measured = +.005

Take your error and multiply it by 5

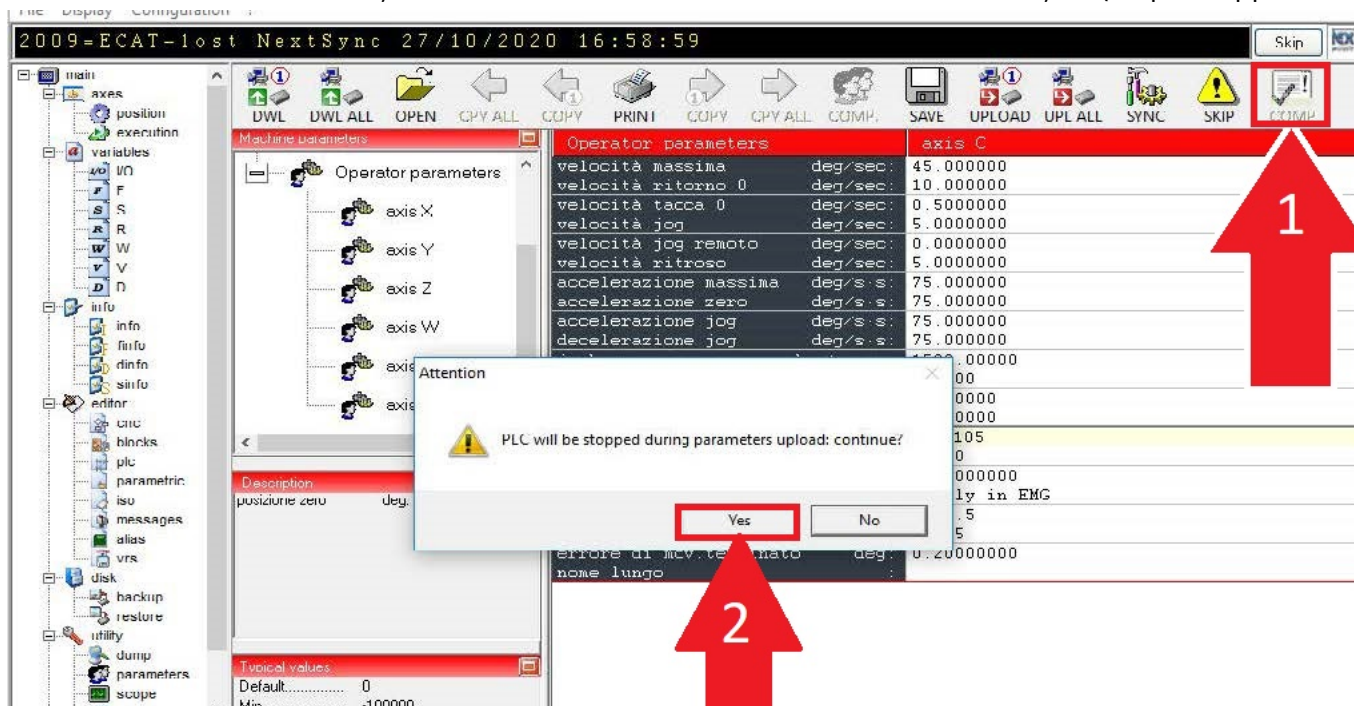
$+.005 \times 5 = +.025$

Original Zero Position = $174.13 - .025 = 174.105$ New zero position = 174.105

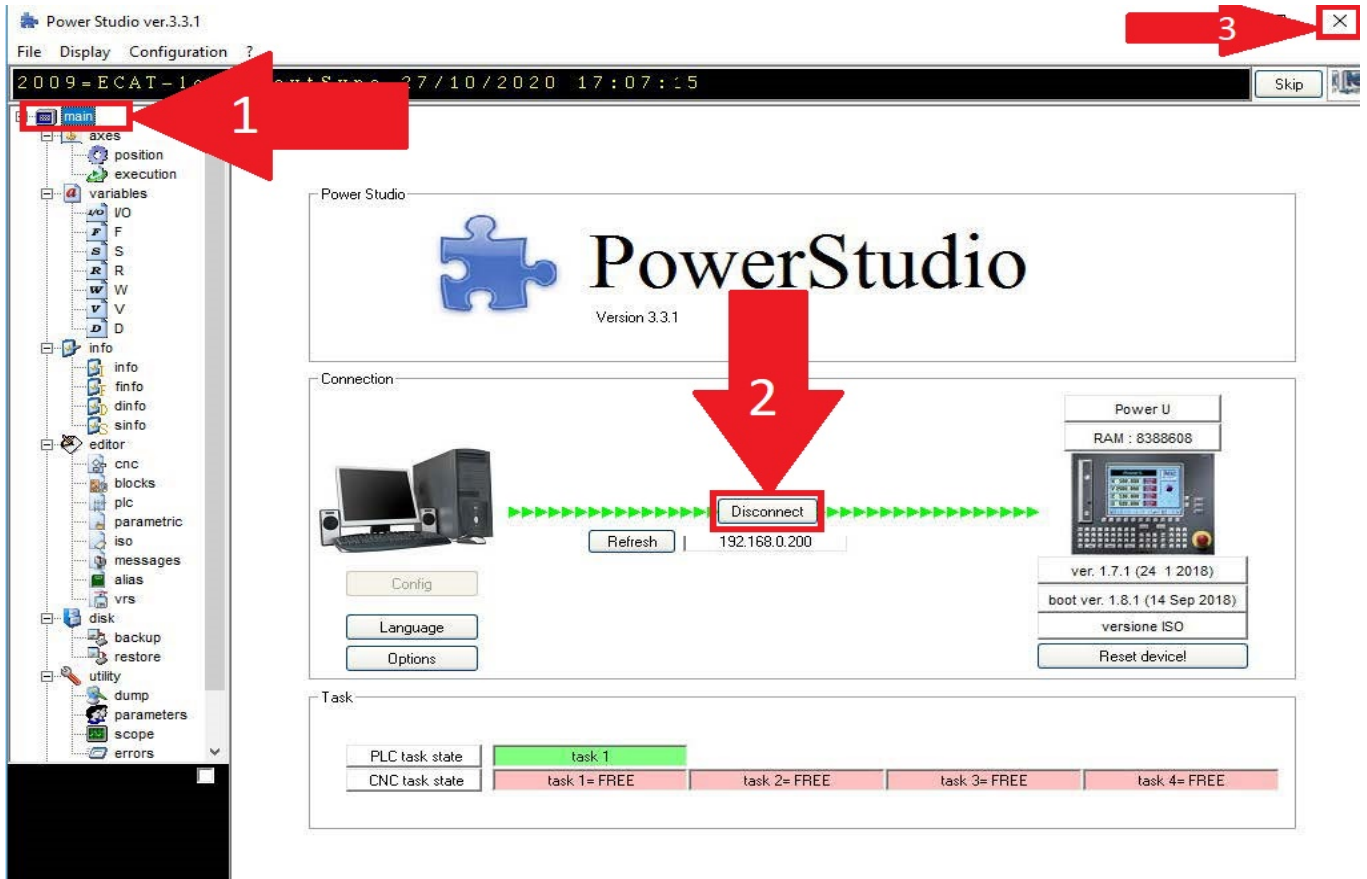
- Input your new ZERO POSITION value (step 1)
- Click UPLOAD 1 or UPLOAD ALL (step 2)



- On newer machines, simply click yes (step 2)
- On older machines, you will need to click COMP first if available then yes. (step 1 if applicable)



- Click MAIN on the menu on the left hand side (step 1)
- Click DISCONNECT (step 2)
- Close the PowerStudio Window (step 3)



- Move the head away from the magnetic indicator
- Reset all axis (On the main screen click F1 and F1 again, then click YES to reset Axis)
- Re-measure the C Axis tram.
- Repeat process as needed